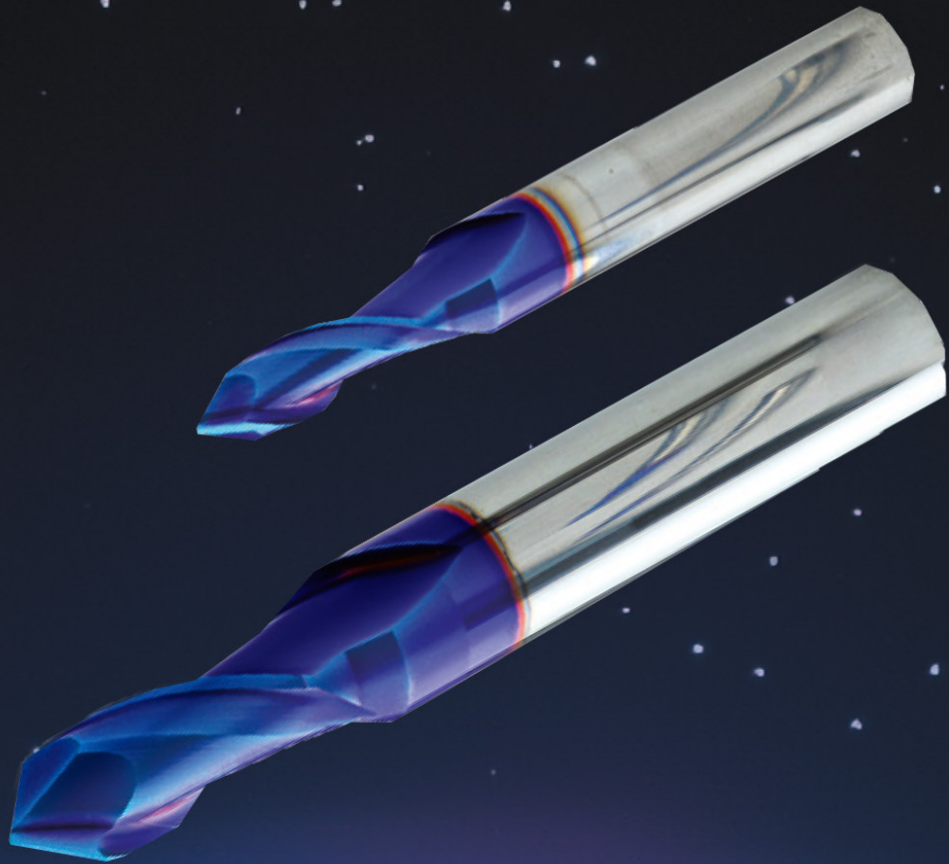




**HARRY HERSBACH  
TOOLS BV**

specialist in machining tools

2024



**COMBIDEX**®

solid solutions to improve your business

**MTMF**

THREADING

MILLING

THREAD MILLING

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**Combidex**

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# INDEX MTMF

## MTMF

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## 1.1 MTMF | Information

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### MTMF MILLING TOOL MULTI-FUNCTIONAL

Combindex introduces a new line of multi-functional milling tools.

#### Carbide grade FXFL3

Ultra-Fine carbide grade with high hardness and toughness provides high cutting edge stability and wear resistance. A New Generation of PVD Coating for High-Performance Cutting Applications. FXFL3 is the general solution grade for most of the applications. Mainly for machining soft steels, cast iron, stainless steels and super alloys.

#### Carbide grade FXFL5

FXFL5 is more dedicated to hard materials and the super alloys with high Ni, Cr, Ti content. When machining high abrasive materials, the FXFL5 provides a higher wear resistance and prolongs the tool life. Both grades share the same cutting data table. The appropriate grade is selected according to the workpiece material.

#### Advantages

- Performs multiple operations with one tool.
- Eliminates tool changes.
- Reduces programming and setup times.
- Reduces tool inventories.
- Ideal for machines with a limited number of tool stations.

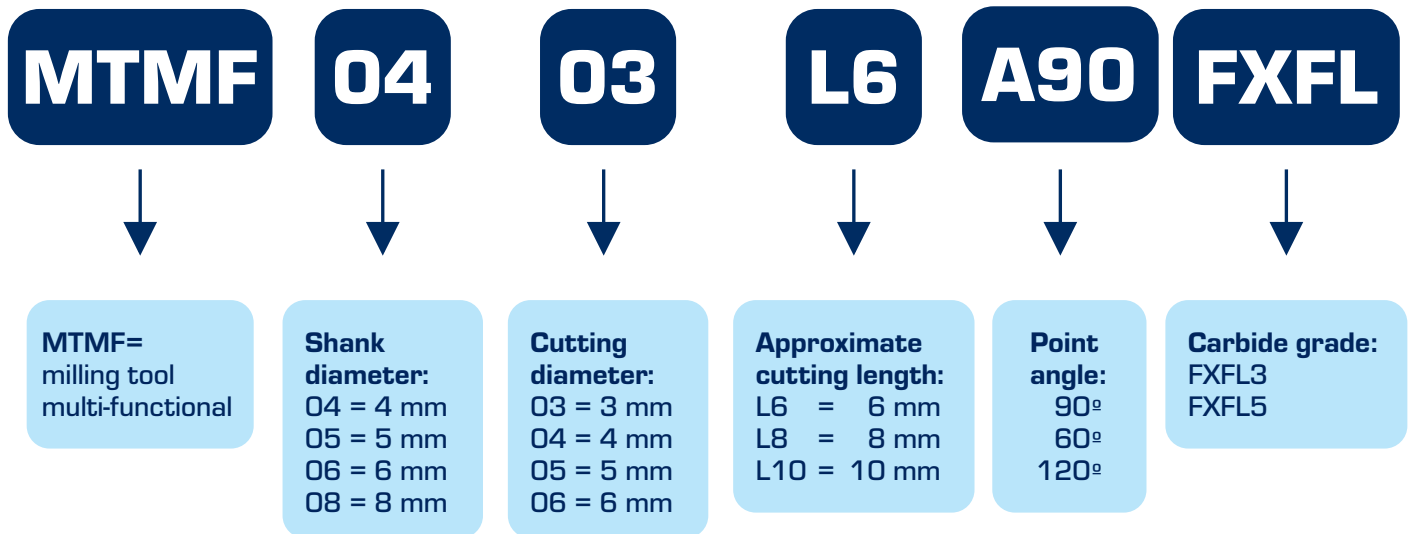
#### Applications

- Spotting and Drilling
- Side milling
- Chamfering
- Slotting
- Grooving
- Engraving

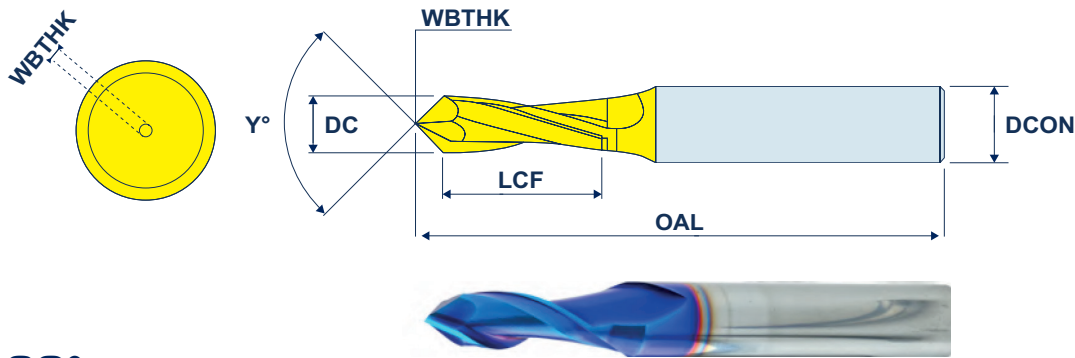


## 1.2 MTMF | Ordering codes

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# 1.3 MTMF MILLING TOOL MULTI-FUNCTIONAL | 60°, 90° & 120°



## 60°

Ordering code	DCON	DC	Y°	WBTH	LCF	OAL
MTMF 0403 L6 A60	4	3.0	60°	0.3	6.0	51
MTMF 0504 L8 A60	5	4.0	60°	0.4	8.0	51
MTMF 0605 L10 A60	6	5.0	60°	0.5	10.0	58
MTMF 0806 L12 A60	8	6.0	60°	0.6	12.0	64
MTMF 1008 L16 A60	10	8.0	60°	0.8	16.0	73
MTMF 1210 L18 A60	12	10.0	60°	1.0	18.0	84
MTMF 1212 L20 A60	12	12.0	60°	1.2	20.0	84

## 90°

Ordering code	DCON	DC	Y°	WBTH	LCF	OAL
MTMF 0403 L6 A90	4	3.0	90°	0.3	6.0	51
MTMF 0504 L8 A90	5	4.0	90°	0.4	8.0	51
MTMF 0605 L10 A90	6	5.0	90°	0.5	10.0	58
MTMF 0806 L12 A90	8	6.0	90°	0.6	12.0	64
MTMF 1008 L16 A90	10	8.0	90°	0.8	16.0	73
MTMF 1210 L18 A90	12	10.0	90°	1.0	18.0	84
MTMF 1212 L20 A90	12	12.0	90°	1.2	20.0	84

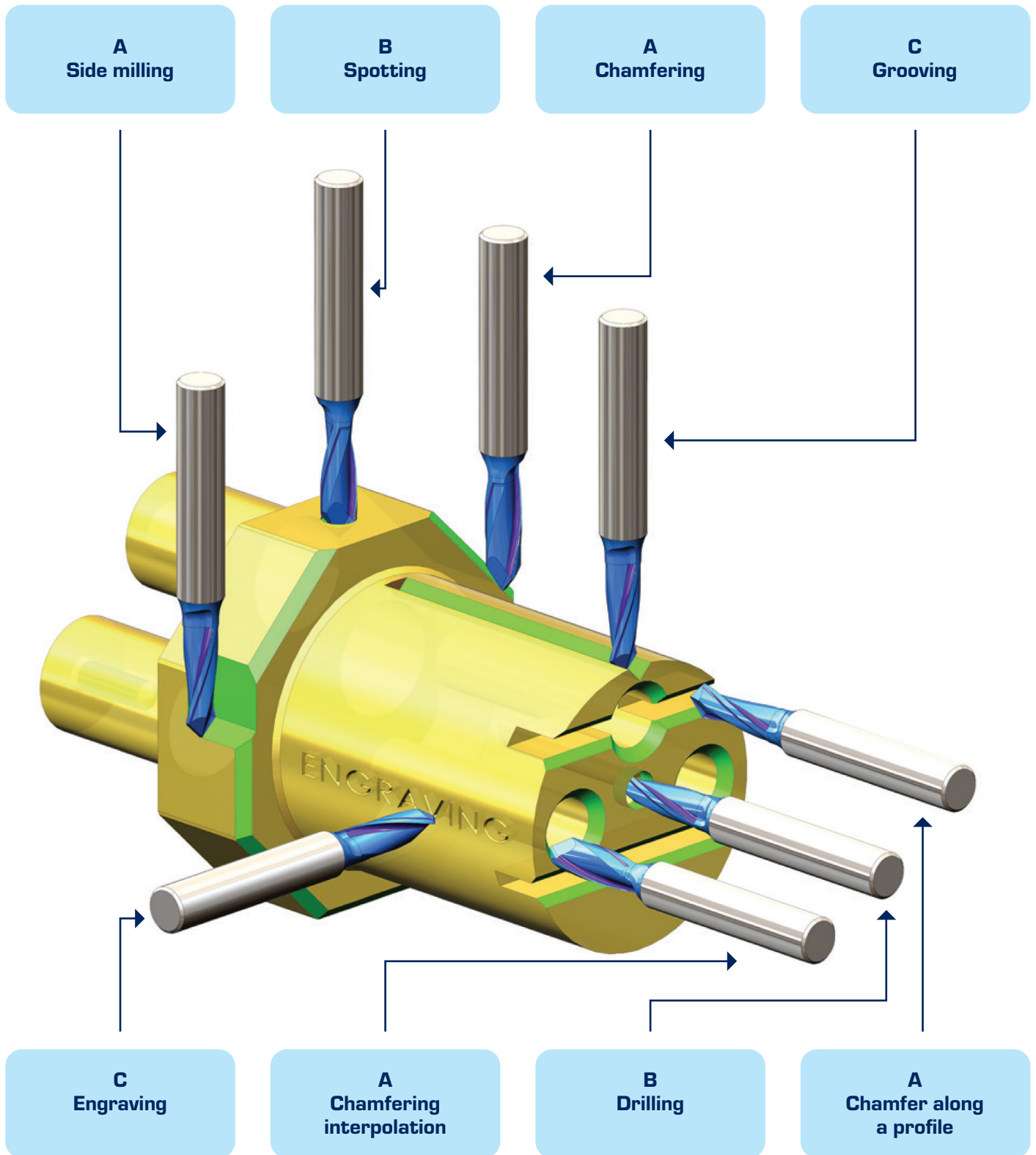
## 120°

Ordering code	DCON	DC	Y°	WBTH	LCF	OAL
MTMF 0403 L6 A120	4	3.0	120°	0.3	6.0	51
MTMF 0504 L8 A120	5	4.0	120°	0.4	8.0	51
MTMF 0605 L10 A120	6	5.0	120°	0.5	10.0	58
MTMF 0806 L12 A120	8	6.0	120°	0.6	12.0	64
MTMF 1008 L16 A120	10	8.0	120°	0.8	16.0	73
MTMF 1210 L18 A120	12	10.0	120°	1.0	18.0	84
MTMF 1212 L20 A120	12	12.0	120°	1.2	20.0	84

ISO	FXFL3	FXFL5
P	•	o
M	•	
K	•	o
N	•	
S	•	•
H	o	≤ 56 HRC

First choice : ●  
Alternative : ○

# 1.4 MTMF| Working methods

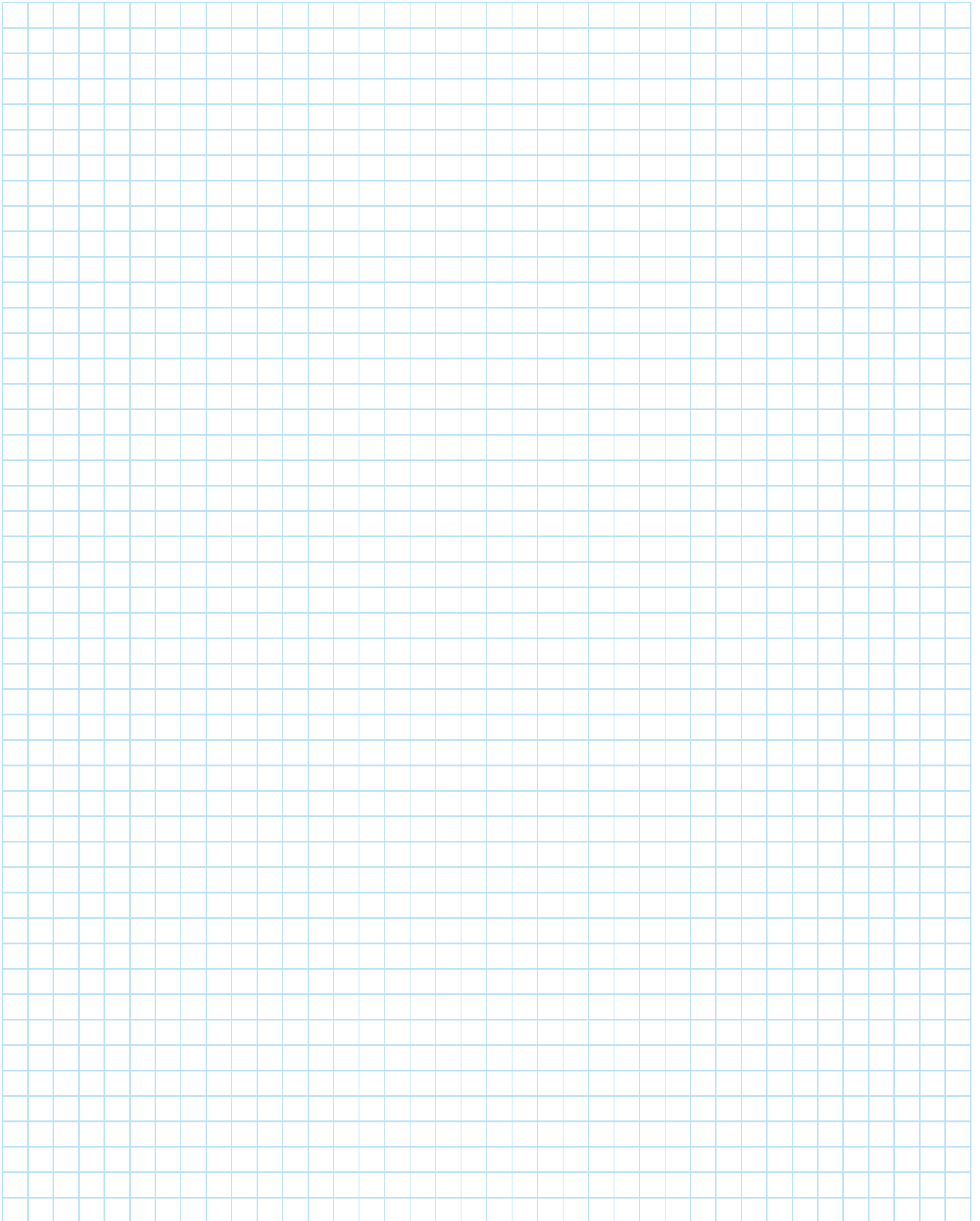


# 1.5 MTMF | Cutting data

A : Side milling chamfering  
 B : Spottingdrilling  
 C : Groovingengraving

ISO Standard	Material	VC (m/min)	FZ MM/TOOTH cutting diameter		
			Ø3 - Ø4	Ø5 - Ø6	Ø8 - Ø12
<b>P</b>	LOW & MEDIUM CARBON STEELS <0.55%C	50-115	A: 0.003-0.01 B: 0.003-0.007 C: 0.005-0.015	A: 0.005-0.02 B: 0.004-0.009 C: 0.006-0.025	A: 0.013-0.038 B: 0.007-0.015 C: 0.015-0.038
	HIGH CARBON STEELS ≥55%C	40-100	A: 0.002-0.012 B: 0.003-0.007 C: 0.005-0.018	A: 0.005-0.018 B: 0.006-0.01 C: 0.01-0.028	A: 0.009-0.03 B: 0.009-0.018 C: 0.016-0.047
	ALLOY STEELS, TREATED STEELS	40-100	A: 0.002-0.008 B: 0.003-0.006 C: 0.005-0.015	A: 0.005-0.015 B: 0.004-0.009 C: 0.005-0.018	A: 0.013-0.031 B: 0.006-0.015 C: 0.015-0.031
<b>M</b>	STAINLESS STEEL-FREE CUTTING	30-85	A: 0.004-0.012 B: 0.003-0.007 C: 0.004-0.018	A: 0.007-0.018 B: 0.004-0.016 C: 0.006-0.018	A: 0.018-0.047 B: 0.008-0.024 C: 0.012-0.047
	STAINLESS STEEL-AUSTENITIC	25-70	A: 0.005-0.010 B: 0.003-0.006 C: 0.004-0.015	A: 0.006-0.015 B: 0.004-0.015 C: 0.005-0.017	A: 0.017-0.04 B: 0.007-0.02 C: 0.01-0.035
	CAST STEELS	40-90	A: 0.004-0.012 B: 0.003-0.007 C: 0.004-0.018	A: 0.007-0.018 B: 0.004-0.016 C: 0.006-0.018	A: 0.018-0.047 B: 0.008-0.024 C: 0.012-0.047
<b>K</b>	CAST IRON	30-120	A: 0.003-0.01 B: 0.003-0.007 C: 0.005-0.015	A: 0.005-0.02 B: 0.004-0.009 C: 0.006-0.025	A: 0.013-0.038 B: 0.007-0.015 C: 0.015-0.038
<b>N</b>	ALUMINUM ≤12%SI, COPPER	90-120	A: 0.005-0.008 B: 0.004-0.007 C: 0.005-0.008	A: 0.01-0.02 B: 0.008-0.015 C: 0.01-0.02	A: 0.025-0.045 B: 0.02-0.04 C: 0.025-0.045
	ALUMINUM >12%SI	75-100	A: 0.003-0.006 B: 0.003-0.005 C: 0.003-0.008	A: 0.005-0.015 B: 0.006-0.01 C: 0.005-0.015	A: 0.02-0.032 B: 0.015-0.035 C: 0.02-0.032
	SYNTHETICS, DUROPLASTICS, THERMOPLASTICS	90-120	A: 0.005-0.008 B: 0.004-0.007 C: 0.005-0.008	A: 0.01-0.02 B: 0.008-0.015 C: 0.01-0.02	A: 0.025-0.045 B: 0.02-0.04 C: 0.025-0.045
<b>S</b>	NICKEL ALLOYS, TITANIUM ALLOYS	20-60	A: 0.004-0.008 B: 0.003-0.007 C: 0.002-0.005	A: 0.007-0.01 B: 0.006-0.008 C: 0.005-0.007	A: 0.01-0.025 B: 0.008-0.02 C: 0.007-0.015
<b>H</b>	HARDENED STEEL 45-50 HRC	20-60	A: 0.005-0.009 B: 0.004-0.008 C: 0.003-0.006	A: 0.008-0.015 B: 0.007-0.009 C: 0.006-0.008	A: 0.015-0.03 B: 0.009-0.025 C: 0.008-0.02
	HARDENED STEEL 45-56 HRC	10-50	A: 0.004-0.009 B: 0.003-0.008 C: 0.002-0.006	A: 0.007-0.015 B: 0.006-0.009 C: 0.005-0.008	A: 0.014-0.03 B: 0.008-0.025 C: 0.007-0.02





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